



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G18251-3G

Job Sheet 172381



est 116

Part No: RBW6305G18251-3G

Job Qty: 3 ea

Part Name: Guide Pumps/Ecs Drive Quill Seal Housing Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G18251-3G Rev A IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		<i>AT 18/04/18</i>
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		<i>AT 18/04/18</i>
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		<i>38</i>
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3		<i>18-04-18</i>
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21	<i>mat 18/04/18</i>	<i>GA 104</i>

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: *039084* MANUFACTURE RBW6305G18251-3G AS PER
Descriptions: DWG -Certificate of conformity is required

FEB 22 2018

uob

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G18251-3GP	Guide Pumps/Ecs Drive Quill Seal Housing Installer	3 (1 ea)	100-Purchasing	<i>506466</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G18251-3GP	3	0	0

Part Specifications

Specifications could not be found.

Plex 2/16/18 8:38 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

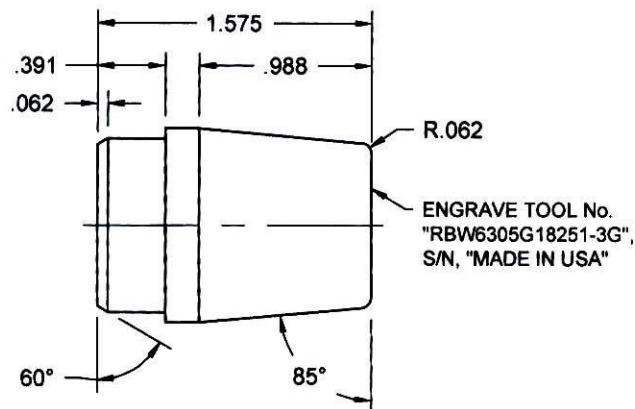
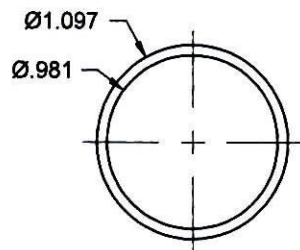
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																																
Change No: Operation: Revision: Serial No/Batch: S061479 PART NO: RBW6305G18251-3G Guide Pumps/Ecs Drive Quill Seal Housing Installer Packaging Mfg Date: 04/16/18 Job No: 172381				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verificati ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> </table>				Environment ☐	No Re-verificati ☐			Design ☐	Operator ☐			Doc/Data ☐	Offset/Setup ☐			Equip/Tooling ☐	Supplier ☐			Handling/Pre ☐	Training ☐			Material ☐	Use for Testing ☐			Internal Transport ☐	Poor Information ☐			Tribal Knowledge ☐	Rushing ☐			LOA ☐	Product Improvement ☐			Substation ☐	Process Improvement ☐			Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			rge ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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OTHER : _____																																																				

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	CH'D TOOL NAME WAS DRIVE QUILL SEAL GUIDE IS GUIDE, PUMPS/ECS DRIVE QUILL SEAL HOUSING INSTALLER TO MATCH PARTS MANUAL.	11/1/13	RJC
			RW



NOTES

- PART OF KIT RBW6305G01531-3G, BOX ONE RBW6305G19631-3G.

RED BARN MACHINE	
TITLE GUIDE, PUMPS/ECS DRIVE QUILL SEAL HOUSING INSTALLER	
DWG NO. RBW6305G18251-3G	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	METRIC REF.
DECIMALS .XX ± .005	.XXmm ± .1mm
.XX ± .01	FRACTIONS ± 1/32
X ± 1	ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-4-11
SHEET 1 of 1	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
				1	DRIVE QUILL SEAL GUIDE	6061 RND. BAR	Ø1-1/8 x 1-3/4	
ASSY #								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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PURCHASE ORDER PO039084

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
Line Item Note	job# 172405										
23	RBW6305G13731-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G13731-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$362.28/Ea	\$1,086.84
Line Item Note	job# 172401										
24	RBW6305G13231-3GP			Gimball Carbon Seal Installer As Per Dwg RBW6305G13231-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$984.42/Ea	\$2,953.26
Line Item Note	job# 172399										
25	RBW6305G14031-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G14031-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$639.24/Ea	\$1,917.72
Line Item Note	job# 172397										
26	RBW6305G14331-3GP			Upper Module Lip Seal Installer As Per Dwg RBW6305G14331-3G Rev. 1	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$758.42/Ea	\$2,275.26
Line Item Note	job# 172382										
27	RBW6305G18251-3GP			Guide Pumps/Ecs Drive Quill Seal Housing Installer As Per Dwg RBW6305G18251-3G Rev. A	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$132.32/Ea	\$396.96
Line Item Note	job# 172381										
28	RBW6305G17631-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Remover As Per Dwg RBW6305G17631-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$496.30/Ea	\$1,488.90
Line Item Note	job# 172378										
29	RBW6305G17931-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Installer As Per Dwg RBW6305G17931-3G Rev. B	Firmed	4/9/18	3 Ea	0 Ea	3 Ea	\$392.72/Ea	\$1,178.16
Line Item Note	job# 172377										
30	RBW6305G17131-3GP			Drive Quill Seal Housing Removal Tool As Per Dwg RBW6305G17131-3G Rev. 3	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$905.64/Ea	\$2,716.92
Line Item Note	job# 172376										



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 039084 Dated: 4/12/2018

Our Order / Job No: 05AWT Order Qty: 3

Part Name: DRIVE QUILL SEAL GUIDE

Part Number: RBW6305G18251-3G

Lot Size: N/A Ship Date: 04/12/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G18251-3G Rev: A

Material Size and Type: 6061 ALUMINUM

Material Specifications: ALUM-ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/12/18

Signed: Hernan-M. Pacheco

PHGE Machine Works LLC dba Arrow Tech Machine Works
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